

[illegible]

Rev	Date	Change	Revised By	Approved

5/15

GUT

DART AEROSPACE LTD		Work Order:	22493B
Description: Bearpaw Kit (19" x 24")		Part Number:	K10008
Dwg: D2432 Rev. F3		Qty:	11 15 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1	

Page 1 of 1																																																					
Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	JA	05.02.21	15																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	WR 13 JA JA	05.03.17	14																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15426	me	05/03/14	14																																																
4	MV	Inspect material for defects or damage prior to machining	me	05/03/14	14																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	me	05/03/11	14																																																
6	QC2	Inspect parts as they come off the CNC machine	me	05/03/11	14																																																
7	MV	Deburr	me	05/03/11	14																																																
8	QC8 & 5	Second inspection	me	05/03/11	14																																																
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434/B219540/B21185</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20927/B21585/B21846</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B22493</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B21189</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B21527A</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M14526</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M15993</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434/B219540/B21185	12	D2274	Radius Block	B20927/B21585/B21846	2	D2432F	24" Bearpaw	B22493	6	D2438	Clamp	B21189	12	D2529	Washer	B21527A	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	M15321	12	AN4-17A	Bolt	M14526	24	AN960JD416	Washer	M15993	12	MS21042L4	Nut (or -4)	M15020	1	Paperwork package from Step 2			me	05/03/11	14
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SG	05/03/16	11																																																
11	PK	Identify and pack for shipping as per PPP K10008	CG	05/03/17	11																																																
12	AC	Cost / part 251.50 REV. E	me	05/03/17	11																																																
13	DC	Close W/O 274.25 Inspect Level 21	SG JA	05.03.21 05.03.17	11																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	#

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SPUR

DART AEROSPACE LTD	Work Order:	22493 <i>17</i>
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	15 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	<i>JA</i>	05.02.21	15
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	<i>WR 13 JA</i> <i>TH</i>	05.03.09	1
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: <i>M15926</i>	<i>me</i>	05/03/09	1
4	MV	Inspect material for defects or damage prior to machining	<i>me</i>	05/03/09	1
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	<i>me</i>	05/03/09	1
6	QC2	Inspect parts as they come off the CNC machine	<i>me</i>	05/03/09	1
7	MV	Deburr	<i>me</i>	05/03/09	1
8	QC8 & 5	Second inspection	<i>EE</i>	05.03.09	1
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434 12 D2274 Radius Block B20927 2 D2432F 24" Bearpaw B22493 6 D2438 Clamp B21189 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433 12 AN4-15A Bolt m8525/m14115/m14349 12 AN4-17A Bolt m12692 24 AN960JD416 Washer m15993 12 MS21042L4 Nut (or -4) m15020 1 Paperwork package from Step 2	<i>CL</i>	05/03/09	1
10	QC4	Inspect Kit for 100% Completeness on the W/O	<i>JB</i>	05/03/09	1
11	PK	Identify and pack for shipping as per PPP K10008 <i>REV E</i>	<i>CL</i>	05/03/10	1
12	AC	Cost / part <i>224.20</i>	<i>scf</i>	05.03.10	1
13	DC	Close W/O <i>224.20</i> Inspect Level 21	<i>JA</i>	05.03.10	1

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H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

PR 05-03-10

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22493 C

DART AEROSPACE LTD	Work Order:	22493
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	3 15 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HA	05.02.21	15
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	DK	05.04.05	3
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15426	ML	05/03/04	6/6
4	MV	Inspect material for defects or damage prior to machining	ML	05/03/04	6/6
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	ML	05/03/11	14
6	QC2	Inspect parts as they come off the CNC machine	ML	05/03/11	14
7	MV	Deburr	ML	05/03/11	14
8	QC8 & 5	Second inspection	TE	05/03/11	14
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434/B19540/B21185/B22505 12 D2274 Radius Block B20427/B21585/B21846 2 D2432F 24" Bearpaw B22493 6 D2438 Clamp B21189 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433/B22505 12 AN4-15A Bolt M15321 12 AN4-17A Bolt M14506 24 AN960JD416 Washer M13993 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2	CL	05/03/14	3
10	QC4	Inspect Kit for 100% Completeness on the W/O	SB	05/03/28	3
11	PK	Identify and pack for shipping as per PPP K10008	CL	05/03/28	3
12	AC	Cost / part 168.15	540	05.03.29	3
13	DC	Close W/O 29.21 Inspect Level 21	HA	05.04.05	3

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BP 05-03-30

RELEASER